



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

Black Gloss

D4417-011
Job Sheet 179195



Part No: D4417-011

Job Qty: 1 ea

Part Name: Q.R. Step Assembly (206L/407)



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/14/18

Job Tracking No:

Due Date: 6/22/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D4417 REV B SHEETS 1,2, D2690 REV B2 IPP REV:A NEW ISSUE 11-07-11 JLM VERIFIED BY:EC
IPP REV:B 11.08.17 PER REV.B. DD VERF:JLM IPP REV:C 11.10.25 replace D2690-6 for CBL-460 & CBL-1240 for assembling purpose DD verf:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier			
90	Start up Operation	1 Ea	6/22/18	6/22/18	0.00	0.00	Start Up Stores/Pkg-1			DAS JUN 14 2018
100	Packaging	1 pcs	6/22/18	6/22/18	0.00	0.00	Packaging1-5			89 2118-6-20
120	HandFinish	1 pcs	6/22/18	6/22/18	0.00	0.58	HandFinish4			DAS 18-6-20
130	QC	1 pcs	6/22/18	6/22/18	0.00	0.00	QC5			38
210	Packaging	1 pcs	6/22/18	6/22/18	0.00	0.00	Packaging3-2			DAS 11.9.18
220	QC21-SA	1 Ea	6/22/18	6/22/18	0.00	0.00	QC21			21 JUL 10 2018

Part Op 120 - 1- ASSEMBLE AS PER DWG 2- USE CBL-1240 AND CBL-460 TO MAKE D2690-6. CUT CBL-1240 CABLE AND Descriptions: CRIMP CBL-460 AS PER DWG D2690

PK002

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN4C16A	Bolt	2 pcs (2 ea)	90-Start up Operation	
AN4C36A	Bolt	2 Ea (2 ea)	90-Start up Operation	
CBL-1240	Cable	.7080 ft (.708 ea)	90-Start up Operation	
CBL-460	Loop Sleeve	2 Ea (2 ea)	90-Start up Operation	5031438
D2570	Bushing	4 Ea (4 ea)	90-Start up Operation	5044355
D4417-041	Step Assembly	1 Ea (1 ea)	90-Start up Operation	5047871
D4418-1	Step Lug	2 Ea (2 ea)	90-Start up Operation	5080867
D4428-1	Bushing	2 Ea (2 ea)	90-Start up Operation	
MS17984-C415	Quick Release Pin	2 Ea (2 ea)	90-Start up Operation	
MS21043-4	Nut	4 Ea (4 ea)	90-Start up Operation	
NAS1149C0432R	Washer	8 Ea (8 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN4C16A	2	44	0
	AN4C36A	2	10	0
	CBL-1240	1	332	0
	CBL-460	2	365	0
	D2570	4	187	0
	D4417-041	1	1	0
	D4418-1	2	8	0
	D4428-1	2	9	0



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Container No: S081259



Part: D4417-011

Job No: 179195

Serial No/Batch: S081259

Revision:

Inspector:

Exp Date:

Instructions:

Date: 06/14/10

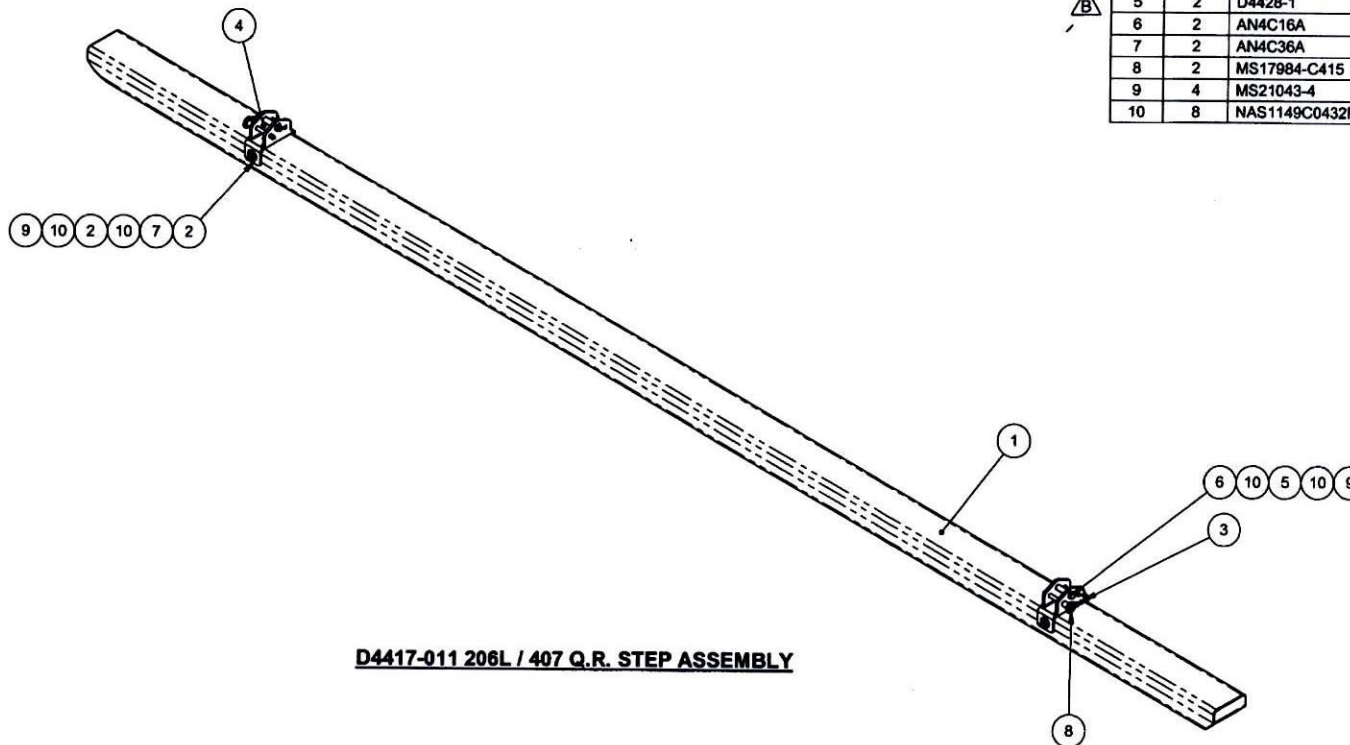
31
32
33

MS17984-C415	2	6	0
MS21043-4	4	713	0
NAS1149C0432R	8	2,031	0

Part Specifications

Specifications could not be found.

Plex 6/14/18 12:30 PM Dart.lajeunesse.marie

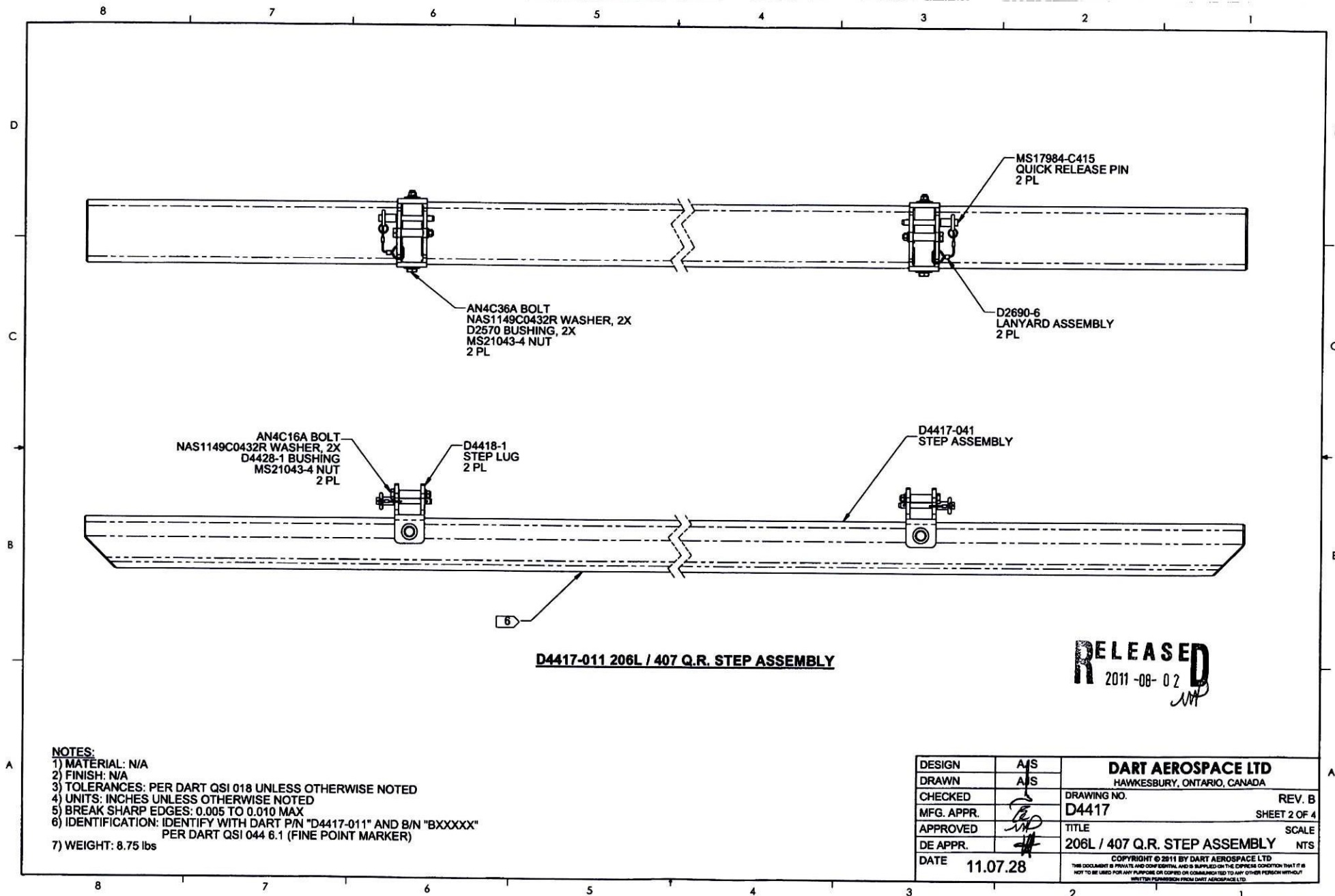


D4417-011 206L / 407 Q.R. STEP ASSEMBLY

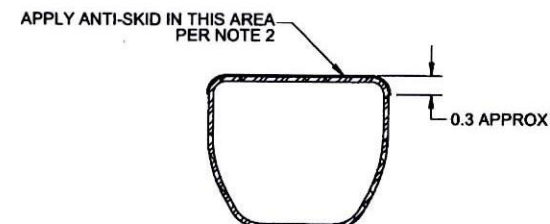
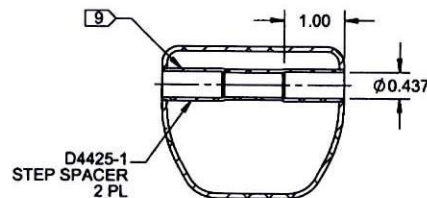
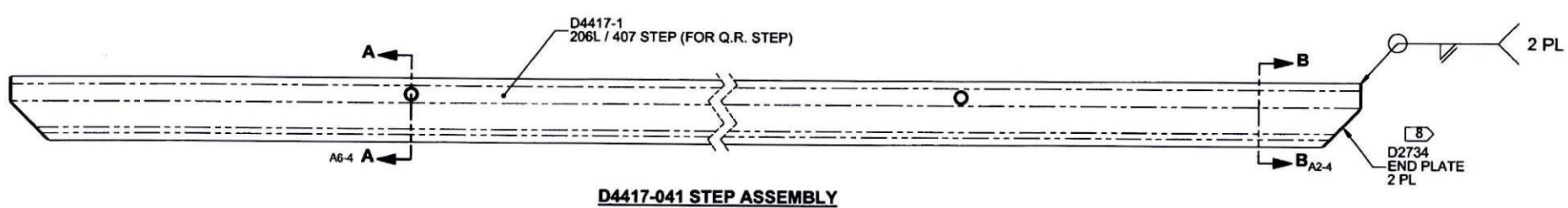
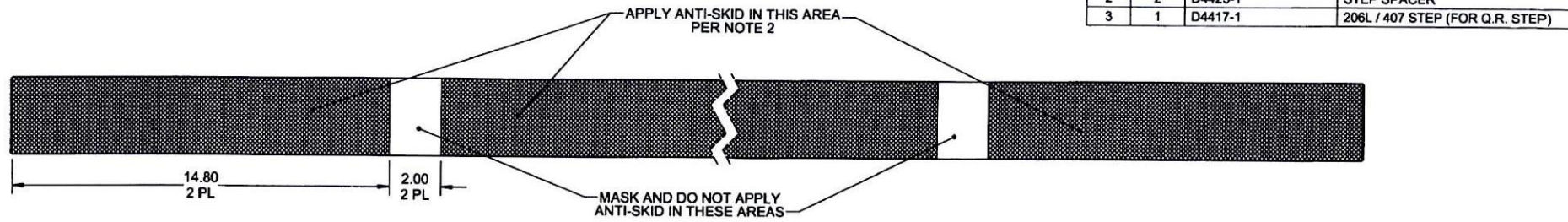
ITEM	QTY -011	P/N	DESCRIPTION
	X	D4417-011	206L / 407 Q.R. STEP ASSEMBLY
1	1	D4417-041	STEP ASSEMBLY
2	4	D2570	BUSHING
3	2	D2690-6	LANYARD ASSEMBLY
4	2	D4418-1	STEP LUG
5	2	D4428-1	BUSHING
6	2	AN4C16A	BOLT
7	2	AN4C36A	BOLT
8	2	MS17984-C415	QUICK RELEASE PIN (BLBS-020)
9	4	MS21043-4	NUT
10	8	NAS1149C0432R	WASHER

RELEASED
2011-08-02

B	REPLACED NAS43DD4-64 SPACER WITH ITEM 5. ITEM 3 WAS -S.	AJS	11.07.28
A	NEW ISSUE	AJS	11.07.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4417	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		206L / 407 Q.R. STEP ASSEMBLY	NTS
DATE	11.07.28	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



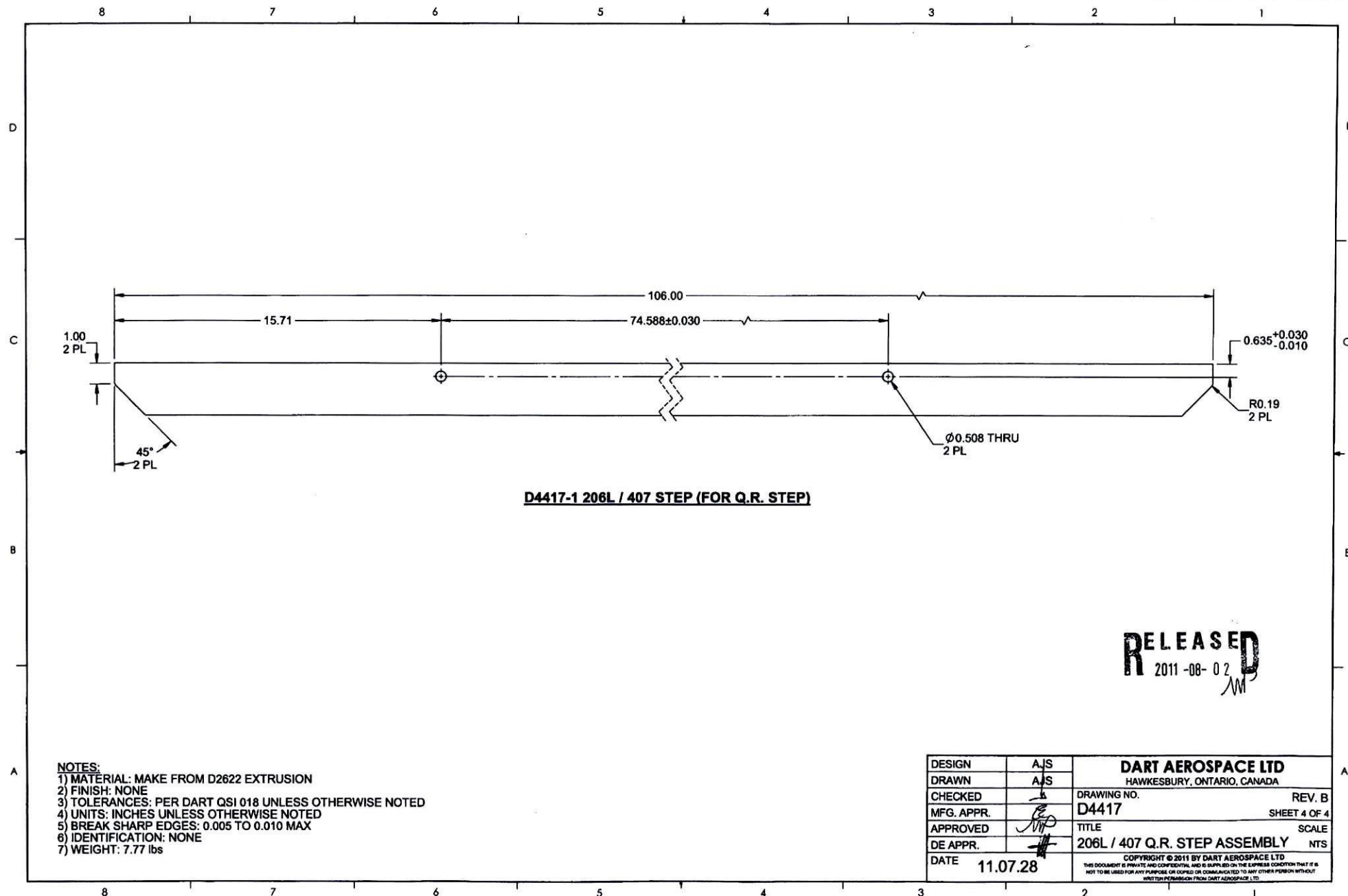
ITEM	QTY	P/N	DESCRIPTION
	X	D4417-041	STEP ASSEMBLY
1	2	D2734	END PLATE
2	2	D4425-1	STEP SPACER
3	1	D4417-1	206L / 407 STEP (FOR Q.R. STEP)



- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 8.00 lbs
 - 8) APPLY ALODINE AFTER WELDING ON THE D2734 END CAPS AND PRIOR TO INSTALLATION OF D4425-1 STEP SPACERS.
 - 9) SWAGE TO $\phi 0.437 \times 1.00$ DEEP PER QSI 002

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO. D4417	REV. B
MFG. APPR.		TITLE 206L / 407 Q.R. STEP ASSEMBLY	SCALE NTS
APPROVED		DATE 11.07.28	
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RELEASED
2011-08-02
MP



RELEASED
2011-08-02

- NOTES:**
 1) MATERIAL: MAKE FROM D2622 EXTRUSION
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: NONE
 7) WEIGHT: 7.77 lbs

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO. D4417	REV. B
MFG. APPR.	<i>[Signature]</i>	SHEET 4 OF 4	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	206L / 407 Q.R. STEP ASSEMBLY	NTS
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Container View (Active) - Master Unit Containers

Master Unit No	Container No	Part No	Part Name	From Container	Current Location	Quantity
003873	S081252	AN4C16A	Bolt	FM136741	ST343	2
003873	S081253	AN4C36A	Bolt	FM135848	ST342	2
003873	S081254	D2570	Bushing	S068688	ST008	4
003873	S081255	D4418-1	Step Lug	S073474	ST535	2
003873	S081256	D4428-1	Bushing	F151527	ST091	2
003873	S041164	MS17984-C415	Quick Release Pin		ST315	2
003873	S081257	MS21043-4	Nut	S062296	ST302	4
003873	S081258	NAS1149C0432R	Washer	S050052	ST266	8

Note: Ad hoc query view of Part.dbo.Container where Container.Active = 1.

Plex 6/14/18 12:44 PM dart.quirion.sonia